Dart Aerospace Ltd. Tuesday, 05/08/2008 3:38:53 PM Julie Lecocq User: **Process Sheet** : FITTING **Drawing Name** Customer : CC-DAR01 Dart Aerospace Ltd. **Job Number** : 40994 : 13338 **Estimate Number** Part Number : D37631 P.O. Number : D3763 REV B **Drawing Number** This Issue : 05/08/2008 S.O. No. : : NC Project Number : N/A Prsht Rev. : MACHINED PARTS **Drawing Revision** : // First Issue Type : 40703 Material Previous Run **Due Date** : 08/08/2008 Qty: 150 Um: Written By Checked & Approved By DD verified by:JLM 08-05-23 : Est Rev:A new issue Comment **Additional Product** Job Number: Description: **Machine Or Operation:** Seq. #: ROUND BAR 1.00" M6061T6R1000 1.0 Total: Comment: Qty.: 0.1313 f(s)/Unit 19.6875 f(s) ROUND BAR 1.00" DOOSAN LATHE DOOSAN LATHE 2.0 Comment: Doosan Lathe 1- Turn as per Folio FA750 Rev: 8 Dwg D3763 Rev: 2-Deburr per dwg D3763 INSPECT PARTS AS THEY COME OFF MACHINE 3.0 QC2

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

QC8 4.0

SECOND CHECK

Comment: SECOND CHECK

PACKAGING 1 5.0

Location:_

PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1 Identify and Stock

KO

Each

Dart Aerospace Ltd

W/O:		WORK ORDER CH	HANGES	3					
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
·		 		····································					
Part No		PAR #: Fault Category:	NCR: Yes	No DQ	A:	Date: _			

QA: N/C Closed: ____ Date: ____

NCR:			WORK ORD	ER NON-CONFORMAN	CE (NCR)					
		Description of NC		Verification	Ammraval	Approval				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector		
,										
				•						
				l İ						

NOTE: Date & initial all entries

Date: `User: '

Tuesday, 05/08/2008 3:38:53 PM

Julie Lecocq

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: FITTING

Job Number: 40994

Part Number: D37631

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(150)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-08-12

Dart Ae	rospace	Ltd						
W/O:			V	VORK ORDER CHANGI	ES			
DATE	STEP	PRO	DCEDURE CH	HANGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			l					
Part No	:	PAR #:	Fault Ca	tegory:	NCR: Yes	lo DQA:	Date: _	
			 	i	QA: N/	C Closed:	Date: _	
NCR:		V	WORK OR	DER NON-CONFORMA	NCE (NCR)			
DATE	OTED	Description of NC		Corrective Action Section		Verification	Approval	Approval
DATE	STEP	Section A Initial	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector

NCR:		V	VORK ORL	DER NON-CONFORMANC	CE (NCR)					
DATE		Description of NC		Corrective Action Section B	Verification	Approval				
	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector		
			I.							

NOTE: Date & initial all entries

Ø 0.50 THRU ∠0.06 x 45° CHAMFER ALL AROUND $\phi_{0.860^{+0.000}_{-0.010}}$ --- 1.090 ---Ø0.201 B -0.05 X 45° CHAMFER 0.545

D3763-1 FITTING

SHOP COPY RETURN TO **ENGINEERING** UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE

D

DESIGN HS		DART AEROSPACE LTD			
DRAWN	HS ,	HAWKESBURY, ONTARIO, CANADA			
CHECKED	186/	DRAWING NO.	REV. B		
MFG. APPR.	List	D3763	SHEET 5 OF 9		
APPROVED	Wil.	TITLE	SCALE		
DE APPR.		END FITTING	NTS		
DATE 08.0	06.23	COPYRIGHT © 2008 BY DART THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPL NOT TO BE USED FOR ANY PURPOSE OR CONFIDENCE.	SED ON THE EXPRESS CONDITION THAT IT IS		

NOTES: 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC M6061T6R) (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.02 lbs

8

DART AEROS	PACE LTD	<u>.</u>		<u> </u>	Work Or	der:	
				<u> </u>	Part Nun	nhar:	
Description:					Part Null	iibei.	
Inspection Dwg:	Rev:					Pa	ge 1 of 1
	FIRST	ARTICLE IN	r—	_	ECKLIST otype		
Drawing .	Tolerance	Actual Dimension	Accept	Reject	Method	1 - (1)	mments
Dimension	4.7						·
R. 580	th.010	,580					<u> </u>
.50	M030	.502					
-860	-,010	, 885					<u>,, , , , , , , , , , , , , , , , , , ,</u>
1.690	+/010 +/010 +/030 +/030	1.091			 		· · · · · · · · · · · · · · · · · · ·
. 545	+1010	. 545					
-201	T.005001	.201					
-05 ×45°	+/030	-05×45°					
		<u> </u>					
	-						
in the second se							
	·						
,							
· · · · · · · · · · · · · · · · · · ·							
Measured by:	O, A	P	rototype A	pproval:			
Date:	28/08/11	Date:	8/08/11			Date:	
Rev Date	Change		7			Revised by	Approved
A Date	New Issue					KJ/JLM	